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006222

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEA62309
Job Sheet 179194



Part No: RBEA62309

Job Qty: 1 ea

Part Name: AS350/355 Field Maintenance



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 8/31/18

Created By: Logan David

Type: Stock

Description:

Note: RBEA62309 rev.12 IPP REV:A 17.12.13 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	1 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Small Fab-4		MLO
105	Small Fab	1 pcs	8/31/18	8/31/18	0.00	1.00	Small Fab-9		MLO DAS
120	QC	1 pcs	8/31/18	8/31/18	0.00	0.00	QC5		NOV 07 2018 68
130	Packaging	1 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-2		MLO 9-89
140	QC21-FG	1 Ea	8/31/18	8/31/18	0.00	0.00	QC21		DAS 21 NOV 07 2018

Part Op 105 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1700-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Install placard to wheel housing as per DWG 6-Glue foam to case and pack case 7- See note 1 for hoses



Container No: S111040



Part: RBEA62309

Job No: 179194

Serial No/Batch: S111040

Revision: 12

Inspector:

Exp Date:

Instructions:

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www.dartaerospace.com

Date: 09/18/18

NOV 10 1905

NOV 10 1905

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	100-Start up Operation	5021040
3896T31	Ferule 1/16 X 3/8" - Aluminum	2 Ea (2 ea)	105-Small Fab	5038398
5274T761	Polypropylene Vial for Flange Wrench Bolts	1 Ea (1 ea)	105-Small Fab	50180460
7189K31	Cable Ties Black	9 Ea (9 ea)	105-Small Fab	5032430
86625K31	Grommet Size 00	1 Ea (1 ea)	105-Small Fab	5038427
9052000	10" Mini Bungee Cord	4 Ea (4 ea)	105-Small Fab	5094606
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	105-Small Fab	5075949
97526A421	Rivet	4 Ea (4 ea)	105-Small Fab	5038428
APP-1700-E	Hard Case	1 Ea (1 ea)	105-Small Fab	5092388
CL-194-TERM-2	Eyelet	1 Ea (1 ea)	105-Small Fab	5041609
CL-2-C	Lanyard Wire	1.1600 ft (1.16 ea)	105-Small Fab	5093863
NAS1756-12	Remove Before Flight	1 Ea (1 ea)	105-Small Fab	5094292
RBE-350DAMPER	Damper Spanner Wrench	1 Ea (1 ea)	105-Small Fab	5107750
RBE-350HYD	Hydraulic Accumulator Fitting Gauge	1 Ea (1 ea)	105-Small Fab	5115954
RBE-350INCLINOMETER	Inclinometer	1 Ea (1 ea)	105-Small Fab	5064583
RBE-350TDRS	Tail Rotor Driveshaft Bearing Run-Out Gauge	1 Ea (1 ea)	105-Small Fab	5115851
RBE-350TEMP	Temperature Probe	1 Ea (1 ea)	105-Small Fab	5091678 5091719
RBE350A93-3200-20	Main Gear Box/Rotor Brake Retaining Nut Wrench	1 Ea (1 ea)	105-Small Fab	5109419
RBE350A93-3205-00E	Engine G/B Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5096004
RBE350A93-3205-00T	Tail Rotor Gear Box Input Flange Holding Wrench	1 Ea (1 ea)	105-Small Fab	5096015
RBE350A93-3300-20	Tail Rotor Hub Socket	1 Ea (1 ea)	105-Small Fab	5117389
RBE350A93-3302-02	Tail Rotor Hub Lock Wrench	1 Ea (1 ea)	105-Small Fab	5123228
RBE350A93-3303-02	Tail Rotor Head Body Extractor Tool	1 Ea (1 ea)	105-Small Fab	5117835
RBE350A93-3305-20-1	Tail Gearbox Wrench	1 Ea (1 ea)	105-Small Fab	5120027
RBE350A93-3307-00	Tail Gearbox Seal Extractor	1 Ea (1 ea)	105-Small Fab	5121689
RBE350A93-3312-03	Tail Rotor Hub Bushing Replacement Tool	1 Ea (1 ea)	105-Small Fab	5121708
RBE350A93-3316-20-1	Rotating Star Replacement Wrench	1 Ea (1 ea)	105-Small Fab	5107555
RBE350A93-3317-20	Tail Rotor Hub Insert Tool	1 Ea (1 ea)	105-Small Fab	5105775
RBE350A93-3400-00	Drive Shaft Thimble	1 Ea (1 ea)	105-Small Fab	5098687
RBE350A93-3500-00	Bearing Extractor	1 Ea (1 ea)	105-Small Fab	5113151
RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing	1 Ea (1 ea)	105-Small Fab	5122684
RBE350A94-2704-00	Pedals Locking Tool	1 Ea (1 ea)	105-Small Fab	5113008
RBE350A94-2706-00	Rigging Pin Set	1 Ea (1 ea)	105-Small Fab	5121872
RBE350A94-2708-01	Tail Rotor Blade Locking Tool	1 Ea (1 ea)	105-Small Fab	5113344
RBE350A94-3301-00	T/R Accelerator Support	1 Ea (1 ea)	105-Small Fab	5113375
RBE350A94-3700-A	Swashplate Immobilizing Tools Long Brace & Parts	1 Ea (1 ea)	105-Small Fab	5115529
RBE350A94-3700-C	Swashplate Immobilizing Tool Adjustable Brace	1 Ea (1 ea)	105-Small Fab	5121970
RBE350A94-3701-00	Main Rotor Rigging Tool	1 Ea (1 ea)	105-Small Fab	5101757
RBE350A94-5201-20	Cartridge, Dummy, Fuel	1 Ea (1 ea)	105-Small Fab	5127215
RBE703A94-1130-01	Main Rotor Blade Trim Tab Tools Assembly	1 Ea (1 ea)	105-Small Fab	5103441
RBE703A95-0505-00	Hose, Main Gear Box Tail Gear Box Draining	1 Ea (1 ea)	105-Small Fab	5028556
RBE703A95-0508-00	Main Rotor Gear Box Drain Tube	1 Ea (1 ea)	105-Small Fab	5099012 5082598
RBE703A95-0520-01	Engine And Hydraulic Drain Tube	1 Ea (1 ea)	105-Small Fab	5099012
RBE703A95-0520-01-11	Tube	1 (1 ea)	105-Small Fab	5099012
RBE703A95-0520-01-13	Cap	1 (1 ea)	105-Small Fab	5099012
RBE703A95-0520-01-15	Foam	1 (1 ea)	105-Small Fab	5099012
RBEA62309-65	Laminated Location Card	1 Ea (1 ea)	105-Small Fab	5038821 5053656
RBEA62309-81	Top Shelf Cushion	1 Ea (1 ea)	105-Small Fab	5092336
RBEA62309-82	Top Cushion Stiffener	1 Ea (1 ea)	105-Small Fab	5092351
RBEA62309-83	Bottom Shelf Cushion	1 Ea (1 ea)	105-Small Fab	5092366
RBEA62310	AS350/355 Engine Strut	1 Ea (1 ea)	105-Small Fab	5113281
RBT18025-13	Linear Scale (50 lbs)	1 Ea (1 ea)	105-Small Fab	5095878
RBW109-3101-58-1-1	Hammer, Steel	1 Ea (1 ea)	105-Small Fab	5095477
RBW109-3101-58-2-1	Hammer, Aluminum	1 Ea (1 ea)	105-Small Fab	5121355

Job Allocations

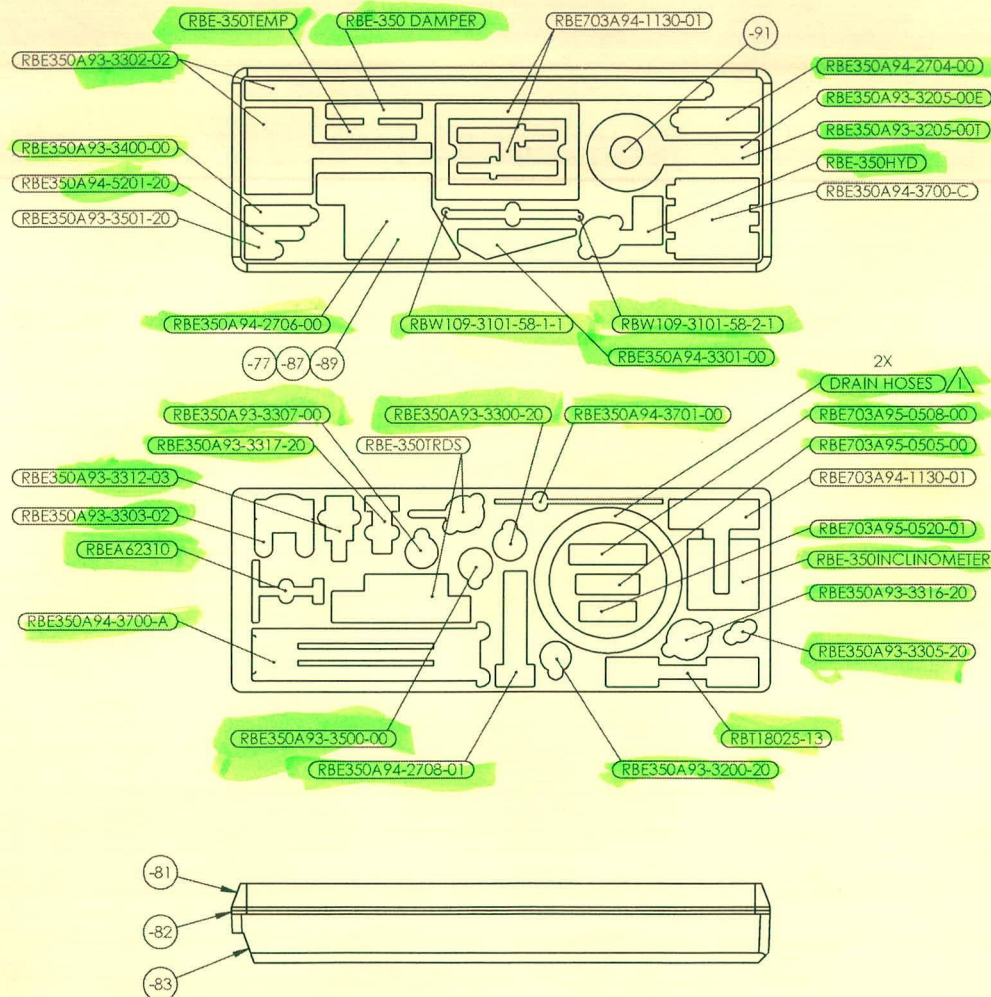
Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	RB41011	1	887	0
105-Small Fab	3896T31	2	498	0
	5274T761	1	10	0
	7189K31	9	1,000	0
	86625K31	1	50	0
	9052000	4	36	0
	97524A032	4	383	0
	97526A421	4	100	0
	APP-1700-E	1	17	0
	CL-.194-TERM-2	1	50	0
	CL-2-C	1	319	0
	NAS1756-12	1	377	0
	RBE-350DAMPER	1	1	0
	RBE-350HYD	1	10	0
	RBE-350INCLINOMETER	1	14	0
	RBE-350TDRS	1	9	0
	RBE-350TEMP	1	1	0
	RBE350A93-3200-20	1	1	0
	RBE350A93-3205-00E	1	8	0
	RBE350A93-3205-00T	1	9	0
	RBE350A93-3300-20	1	12	0
	RBE350A93-3302-02	1	0	0
	RBE350A93-3303-02	1	1	0
	RBE350A93-3305-20	1	0	0
	RBE350A93-3307-00	1	1	0
	RBE350A93-3312-03	1	0	0
	RBE350A93-3316-20	1	1	0
	RBE350A93-3317-20	1	1	0
	RBE350A93-3400-00	1	1	0
	RBE350A93-3500-00	1	0	0
	RBE350A93-3501-20	1	14	0
	RBE350A94-2704-00	1	10	0
	RBE350A94-2706-00	1	1	0
	RBE350A94-2708-01	1	1	0
	RBE350A94-3301-00	1	13	0
	RBE350A94-3700-A	1	2	0
	RBE350A94-3700-C	1	0	0
	RBE350A94-3701-00	1	29	0
	RBE350A94-5201-20	1	11	0
	RBE703A94-1130-01	1	1	0
	RBE703A95-0505-00	1	1	0
	RBE703A95-0508-00	1	3	0
	RBE703A95-0520-01	1	0	0
	RBE703A95-0520-01-11	1	0	0
	RBE703A95-0520-01-13	1	0	0
	RBE703A95-0520-01-15	1	0	0
	RBEA62309-65	1	35	0
	RBEA62309-81	1	8	0
	RBEA62309-82	1	13	0
	RBEA62309-83	1	8	0
	RBEA62310	1	1	0
	RBT18025-13	1	17	0
	RBW109-3101-58-1-1	1	6	0
	RBW109-3101-58-2-1	1	0	0

Part Specifications

Specifications could not be found.

Plex 6/14/18 11:46 AM dart.logan.david

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		REVISIONS		DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		-81 REARRANGED TOP SHELF TOOLS. -83 RECONFIGURED BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. -85 RECONFIGURED TOP AND BOTTOM SHELF TOOL ARRANGEMENT TO BETTER FIT RED BARN TOOLS. ADDED LAMINATED LOCATION CARD AND LANTARD COMPONENTS.		9/22/2009	WP	
2		REPAWNT TO USE HELI-PRODUCTS TOOLS AND ALLOW FOR 3 DRAIN HOSES.		1/25/2010	WP	RW
2A		ADDED NEW RED BARN PHOTOS.		2/11/2010	RJC	PW
3		-81 REARRANGED TOP SHELF TOOLS. -83 REARRANGED BOTTOM SHELF TOOL CUSHION TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. ADDED SECTION A-A TO CLARIFY CUT OUT FOR RBEA94-3701-20. CHD CUTOUT DEPTH FOR RBEA94-3700-A, RBEA94-3701-20 & RBEA93-3501-20. -85 REARRANGED TOP AND BOTTOM SHELF CUSHIONS TO ACCOMMODATE NEW DIGITAL TORPEDO LEVEL. CHD CARD INFORMATION FOR LA 5		2/18/2010	RJC	
4		-83 REARRANGED TOOL CUTOUPS. ADDED CUT OUT FOR RBEA62310. -85 UPDATED CARD.		3/9/2010	WP	
4A		-87 & -81 CHD QTY. FROM 3 TO 1 SET. UPDATED LAYOUT PHOTOS.		5/26/2010	RJC	
4B		-87 & -89 ADDED ONE TO EACH QTY.		7/21/2010	WP	RW
4C		-91 ADDED CONTAINER FOR RBEA93-3205-00-1 & RBEA93-3205-00-25 NUTS & BOLTS.		10/27/2010	WP	DW
5		-81 DELETED CUTOUT NOTCHES FOR RBE-KDGS-15.		6/20/2011	RJC	PW
6		CORRECTED DRAIN HOSE 1/4" FROM RBEA93-0502-01 TO RBEA93-0502-01. -83 CHD FOAM CUTOUPS FOR RBEA93-3300-00, RBEA93-3300-20, RBEA93-3200-20 & RBEA93-3317-20 FOR BETTER FIT. -85 UPDATED CARD.		2/27/2012	RJC	DW
7		-83 CHD TOOL LAYOUT. ADDED NEW DESIGN FOR DRAIN HOSES & CUTOUPS FOR INDIVIDUAL CUTOUPS. CHD CUTOUP FOR RBEA94-3700-A FOR TIGHTER FIT. -85 UPDATED CARD.		1/9/2013	RJC	SE
7A		-85 CORRECTED ITEM QTY FROM RBEA93-3305-02 TO RBEA93-3305-20. CHD QTY. FROM 8 TO 1. ADDED A DRAIN HOSE QTY. 2. CHD LOCATION D1 & D2 TO D, AND X1, X2, & X3 TO X.		4/11/2013	RJC	RJC
8		-81 CHD DIM WAS 4.75 B 4.44. -83 CHD CUTOUP LOCATION FOR RBE350A94-3700-A. -85 CORRECTED 1/4" & TOOL DESCRIPTION TO MATCH CURRENT DRAWINGS.		10/24/2013	CFS	DW
9		-81 CHD CUTOUP FOR RBE-350HYD (NEW GAUGE). CHD CUTOUP FOR RBE350A94-3700-C TO FIT BETTER. -83 CHD CUTOUP FOR RBE350A94-3700-A TO SECURE TOOLS BETTER.		3/25/2014	RJC	DW
10	15-0038	UPDATED TO NEW DRAFTING STANDARDS. -83 CHD FOAM TO ACCOMMODATE SNAP-ON INCLINOMETER. -85 CHD CARD TO SHOW NEW TOOL LAYOUT WITH SNAP-ON INCLINOMETER.		2/11/2015	DPD	JAG
11	16-0149	-81 ADDED DETAIL SHEET. REPLACED RBE-KDGS-15 WITH RBT18025-13 AND MOVED TO -83. ADDED RBW109-3101-58-1 & RBW109-3101-58-2. CHD MATERIAL WAS Y20 BLACK E ETHAFOAM 220, BLACK. -82 ADDED DETAIL SHEET. CHD TOOL LAYOUT. CHD DIM WAS 4X 6.64 IS 3X 6.64 X 4.5. DELETED DIMS: 73 (20), 117 (20), 1.38 (20) & P 75 (14) SPHERE. AND ADDED DIMS: 78, 1.48 & 1.25. CHD FOAM WAS Y20 BLACK E ETHAFOAM 220, BLACK. MOVED RBE350A93-3400-00. RBE350A94-3501-20 & RBE350A93-3501-20 TO -81. -83 RBE-KDGS-15 REPLACED W/ RBT18025-13. -85 REARRANGED TOOLS TOP AND BOTTOM. ADDED RBW109-3101-58-1, RBW109-3101-58-2, RBT18025-13, -77, -87, & -89.		9/20/2016	RJC	JAG
12	17-0013	-81 CHD DIM WAS 8.20 IS .82. -83 CHD DETAIL ORGANIZATION: REMOVED DIM 3 X 9.88, 3X 1.38, 33.47, 24.94, 17, 2.25, 8.07, 7.13. ADDED DIM 67.75, 30.13, 5.49, 12.77, 7.13, 1.38, 5X 8.50, 2X 8.63, 6X 8.13, 6.50. CHD DIM WAS 10.24 B 3X 10.24. WAS 2X 34.88 B 3X 34.88. WAS 12.33 B 8.60. WAS 11.565 B 11.57. -85 REARRANGED TOOLS ON BOTTOM SHELF. UPDATED ITEM 12 & 13 TOOL NUMBERS.		1/24/2017	SM	JAG

NOTE:

7 FT. HOSES MUST COUPLE IN CUTOUT. MIN TRIM ACCEPTABLE.

DART AEROSPACE	
TITLE AS350-355 FIELD MAINTANANCE KIT	
DWG NO. RBEA62309	REV 12
MATL FEAT URAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES ± 12° 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: CLOUGH	QA APPR: LINDSAY
CHECKED: DUERFELDT	APPROVED: GILBERT
OPPS APPR: ANDERSON	USED ON MODEL AS350/355
SCALE 1:8	DATE 9/20/2016 SHEET 1 OF 8

